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**JP-A- 5 321 122**

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## Description

### TECHNICAL FIELD

[0001] The present invention relates to decorative beads which are sewn to a cloth or the like along with embroideries.

### BACKGROUND ART

[0002] By the present applicant, a useful method and an apparatus for embroidering beads are already developed and disclosed in a patent publication (Japanese Patent Application Publication No.5-321122). According to the published known art, by using a stringlike continuous member comprising multiple numbers of cylindrical beads connected in the axial direction, bead embroidery of high quality can be stably performed. The continuous member of beads used in the above mentioned art can be made in various forms by various kinds of method. It is possible to obtain remarkable effects from the beads embroidering method of the published known art by applying any form of the continuous member of beads to the embroidering method.

[0003] However, the applicant intends to innovate the continuous member of beads applicable to the beads embroidering method and apparatus disclosed in the above mentioned publication so as to further efficiently perform the method and apparatus of known art.

[0004] Therefore, it is an object of the present invention to provide beads capable of stably executing bead embroidery having high quality by using a continuous form of beads which can accomplish automatic bead embroidery.

### DISCLOSURE OF INVENTION

[0005] In order to achieve the object, the present invention provides beads that comprise a laminate film formed by laminating films having different thermal shrinkage ratios in a predetermined direction, the laminate film being heat-treated and curled into a cylindrical shape to form beads.

[0006] According to a preferred embodiment of the present invention, the beads are formed in a shape of continuous member comprising a plurality of cylindrical beads divided continuously in the axial direction by forming cuts into a cylinder in the radial direction with a portion of the cylinder left intact as a connecting section between successive beads.

[0007] The present invention further provides a method for producing a continuous member of beads wherein a longitudinal laminate tape formed by laminating films having different thermal shrinkage ratios in the lateral direction of the tape is heat-treated and curled in the lateral direction so as to form longitudinally continuous elongate cylinder and wherein cuts are formed into the cylinder at predetermined intervals with a portion of the

cylinder left intact as a connecting section between successive beads so as to form a continuous member comprising a plurality of cylindrical beads continuous in the axial direction.

[0008] The laminate film is constituted for example from a laminate tape formed by laminating films having different thermal shrinkage ratios in the lateral direction. When the laminate tape is heated, the tape is curled in the lateral direction due to the difference between the thermal shrinkage ratios of the films so that a cylinder is formed from the tape. After that, cuts are formed into the cylinder at predetermined intervals so as to form a continuous member of the cylindrical beads. Even if the curled beads is further heated afterwards, the beads are not uncurled to open, therefore the cylindrical shape is stably maintained.

### BRIEF DESCRIPTION OF DRAWINGS

[0009] Fig.1 is a perspective view of a laminate tape for forming the beads in accordance with the present invention.

[0010] Fig.2 is a perspective view of a cylinder formed by heating the tape of Fig.1.

[0011] Fig.3 is a perspective view of a continuous member of beads made by forming cuts into the cylinder of Fig.2.

### BEST MODE FOR CARRYING OUT THE INVENTION

[0012] Fig.1 is a perspective view of a laminate tape for forming the beads of the present invention. This laminate tape 1a is formed by laminating a first film 2 and a second film 3 made from for example polyester and having different thermal shrinkage ratios in the lateral direction (arrow A) of the tape. The thermal shrinkage ratio of the first film 2 is adjusted to be larger than that of the second film 3. Or the thermal expansion ratio of the second film 3 is adjusted to be larger than that of the first film 2. In either of cases, it is desirable that the shrinkage ratios of the films in the longitudinal direction (arrow B) of the tape be the same.

[0013] By heating the laminate tape 1a with the use of an electric heater or other appropriate heat treatment means, the tape is curled in the lateral direction, as shown in Fig.2, due to the difference between the thermal shrinkage ratios of the films 2 and 3, so that a continuous form of an elongate cylinder 1b is obtained. When the shape of the cylinder is stabilized, the heat treatment is stopped to harden the cylinder.

[0014] After that, cuts 4 are formed by a cutter (not shown) at predetermined intervals into the cylinder 1b with a connecting section 5 left intact between successive beads at a portion of cylinder in the radial direction of each cut section. In that way, a continuous member 1c of beads comprising multiple numbers of beads 6 connected in the axial direction is formed. The continuous member 1c of beads is set in an apparatus which is

itself a known type of apparatus wherein each bead is automatically separated and sewed to a cloth.

[0015] When executing bead embroidery, the laminate tape 1a of Fig.1 is wound in a roll shape first. The tape roll is unwound and the tape is passed through a heating means so as to form the cylinder of Fig.2. After that, the cylinder is successively passed through a cutter means so as to form the continuous member 1c of beads of Fig.3. The continuous member 1c of beads is then successively set in a bead embroidery apparatus. In that way, a series of bead embroidering process can be automated.

[0016] Note that although the laminate tape of the above mentioned embodiment has a two-layer structure, it is possible to use a laminate structure having three layers or more in order to enhance the ornamental effect by thickening the beads or applying different colors to the layers. It is also possible to use various type films such as heat expansive type films, heat contractive type films or combination of the films of both types as the films of the laminate tape to form the cylinder by curling the laminate tape through heat-treatment.

[0017] As mentioned above, in accordance with the present invention, it becomes possible to easily form cylindrical beads with the use of simple means and efficiently automate the bead embroidery process. Also, if heat is applied again to the beads after formed, thermal stress functions to further curl the cylinder rather than uncurling and opening the cylindrical shape, thereby the cylindrical shape is stably maintained.

#### INDUSTRIAL APPLICABILITY

[0018] In the industrial field of bead embroidery technology, beads can be easily formed with the use of simple means and the embroidery process can be efficiently automated as well as the bead shape can be stably maintained which makes it possible to upgrade the quality of bead products.

#### Claims

1. Beads comprising a laminate film formed by laminating films having different thermal shrinkage ratios in a predetermined direction, the laminate film being heat-treated and curled into a cylindrical shape.
2. A continuous member of beads comprising a plurality of cylindrical beads according to claim 1, wherein cuts are formed into a cylinder of said cylindrical shape with a portion in the radial direction being left intact as a connecting section between successive beads continuous in the axial direction of the cylinder.
3. A method for producing the continuous member of

beads according to claim 2, wherein a longitudinal laminate tape formed by laminating films having different thermal shrinkage ratios in the lateral direction of the tape is heat-treated and curled in the lateral direction so as to form longitudinally continuous elongate cylinder and wherein cuts are formed into the cylinder at predetermined intervals with a portion of the cylinder left intact as a connecting section between successive beads so as to form a continuous member comprising a plurality of cylindrical beads continuous in the axial direction.

#### Patentansprüche

1. Perlen, die eine Verbundfolie umfassen, die durch Laminieren von Folien mit unterschiedlichen Wärmeschrumpfungsverhältnissen in einer vorbestimmten Richtung gebildet ist, wobei die Verbundfolie wärmebehandelt und zu einer Zylinderform aufgerollt ist.
2. Kontinuierliches Element aus Perlen, das eine Vielzahl zylindrischer Perlen nach Anspruch 1 umfasst, worin in einem Zylinder der Zylinderform Einschnitte ausgebildet sind, wobei ein Teil in radialer Richtung als Verbindungsabschnitt zwischen in axialer Richtung des Zylinders kontinuierlich aufeinanderfolgenden Perlen intakt gelassen wird.
3. Verfahren zur Herstellung des kontinuierlichen Elements aus Perlen nach Anspruch 2, worin ein längliches Laminatband, das durch Laminieren von Folien mit unterschiedlichen Wärmeschrumpfungsverhältnissen in seitlicher Richtung des Bandes gebildet ist, wärmebehandelt und in seitlicher Richtung aufgerollt wird, um einen länglichen, in Längsrichtung kontinuierlichen Zylinder zu bilden, worin Einschnitte in vorbestimmten Abschnitten im Zylinder ausgebildet werden, wobei ein Teil des Zylinders als Verbindungsabschnitt zwischen aufeinanderfolgenden Perlen intakt gelassen wird, um ein kontinuierliches Element zu bilden, das eine Vielzahl zylindrischer Perlen umfasst, die in axialer Richtung kontinuierlich verlaufen.

#### Revendications

1. Perles comprenant un film laminé formé en laminant des films ayant des rapports de rétrécissement thermique différents dans une direction prédéterminée, le film laminé étant traité par la chaleur et enroulé en une forme cylindrique.
2. Élément continu de perles comprenant une pluralité d perles cylindriques selon la revendication 1, où des coupes sont faites dans un cylindre de ladite

forme cylindrique en laissant intacte une portion dans la direction radiale comme section de connexion entre des perles successives continues dans la direction axiale du cylindre.

3. Procédé pour fabriquer l'élément continu de perles selon la revendication 2, où une bande laminée longitudinale formée par des films laminés ayant des rapports de rétrécissement thermique différents dans la direction latérale de la bande est traitée par la chaleur et enroulée dans la direction latérale de manière à former un cylindre oblong longitudinalement continu, et où des coupes sont faites dans le cylindre à des intervalles prédéterminés en laissant intacte une portion de cylindre comme section de connexion entre des perles successives de manière à former un élément continu comprenant une pluralité de perles cylindriques continues dans la direction axiale.

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Fig. 1

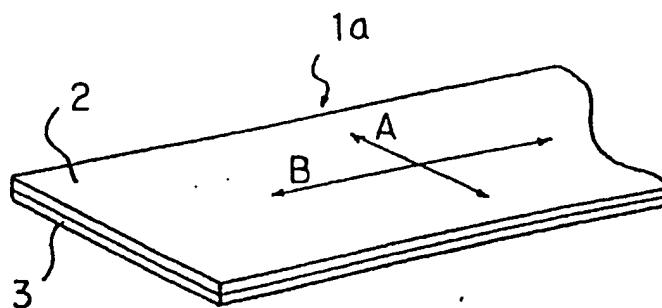


Fig. 2

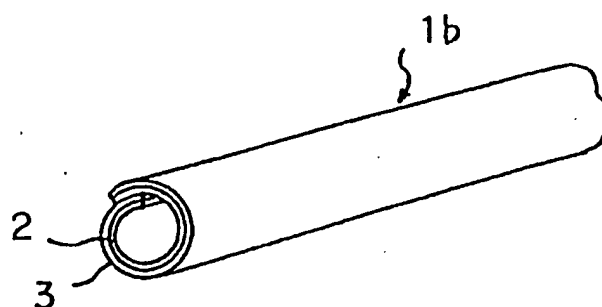
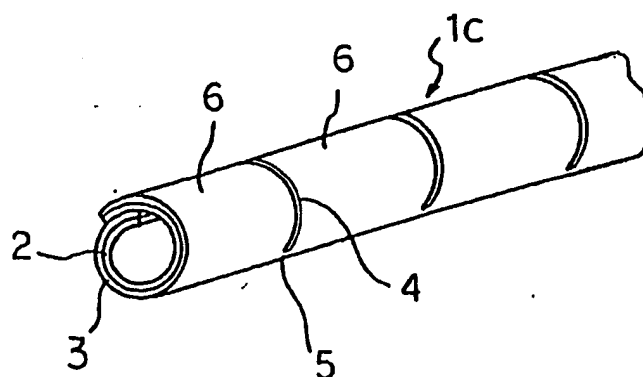


Fig. 3



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